

Date: Friday, 25/07/2008 4:20:47 PM  
 User: Julie Lecocq

## Process Sheet

|                       |  |                  |                              |
|-----------------------|--|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services            | Drawing Name     | : BRACKET                    |
| Job Number            | : 40760  |                  |                              |
| Estimate Number       | : 13512  |                  |                              |
| P.O. Number           | :  | Part Number      | : D21961                     |
| This Issue            | : 25/07/2008 S.O. No. :                          | Drawing Number   | : D2196 REV C                |
| Prsht Rev.            | : NC   | Project Number   | : N/A                        |
| First Issue           | : // Type : SMALL /MED FAB                       | Drawing Revision | : C                          |
| Previous Run          | :  | Material         | :                            |
| Written By            | :  | Due Date         | : 20/08/2008 Qty: 2 Um: Each |
| Checked & Approved By | JLD 08.7.25                                      |                  |                              |
| Comment               | : Est Rev:A 08-07-24 new issue ec verified by:dd |                  |                              |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.: 0.2216 sf(s)/Unit Total : 0.4431 sf(s)

304 SS Sheet 0.063" thick

batch: 108724 HB 8-8-21

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2196

Dwg Rev: C HB 8-8-21

Prog Rev: C

2-Deburr if necessary HB 8-8-21

3

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-21



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/08/01 (13)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per dwg D2196

HB 08/08/25 3

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 25/07/2008 4:20:48 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40760

Part Number: D21961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/08/25 (+3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify wiith Dart part # using a fine point permanent marker and Stock

Location: 18

8/8/25

(3X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



W 08.08.26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

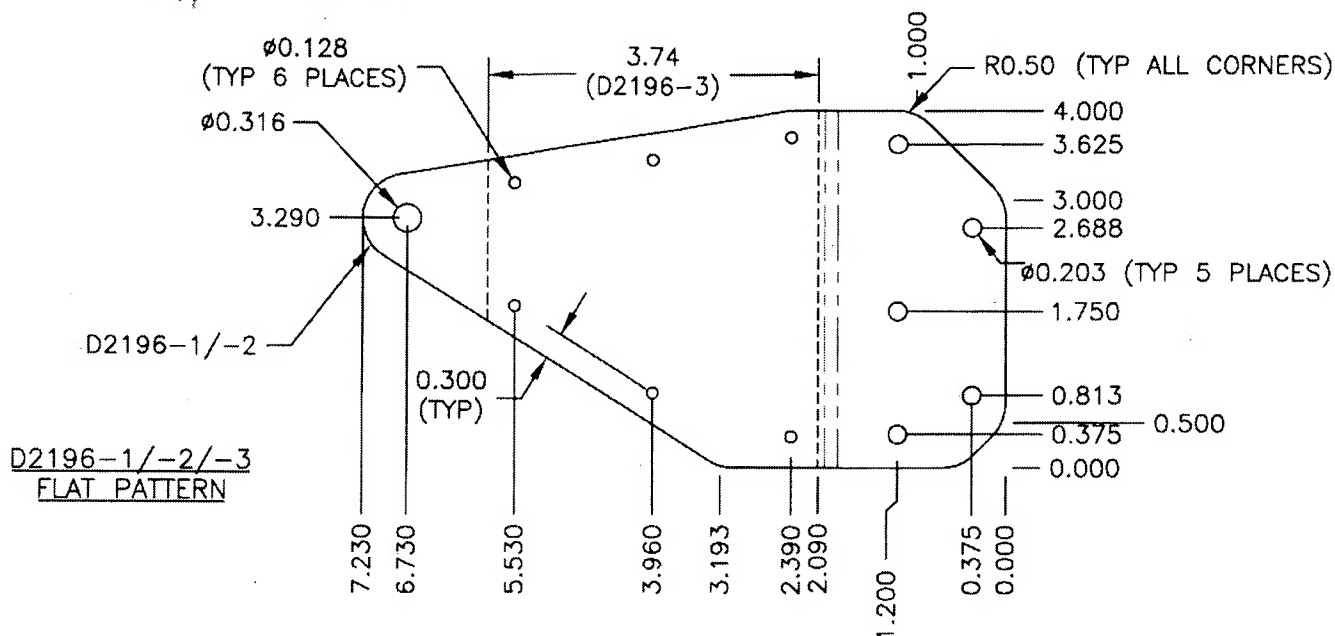
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|          |          |                                |              |
|----------|----------|--------------------------------|--------------|
| DESIGN   | DRAWN BY | DART AEROSPACE LTD             |              |
|          |          | HAWKESBURY, ONTARIO, CANADA    |              |
| CHECKED  | APPROVED | DRAWING NO.                    | REV. C       |
|          |          | D2196                          | SHEET 1 OF 1 |
| DATE     |          | TITLE                          | SCALE        |
| 03.05.28 |          | BRACKET                        | 1:2          |
| B        | 93.09.23 | REDESIGN                       |              |
| C        | 03.05.28 | REDRAW; D2196-3 NOW 0.5" THICK |              |



#### D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.  
0.064" THICK (M304S16GA)

#### D2196-3

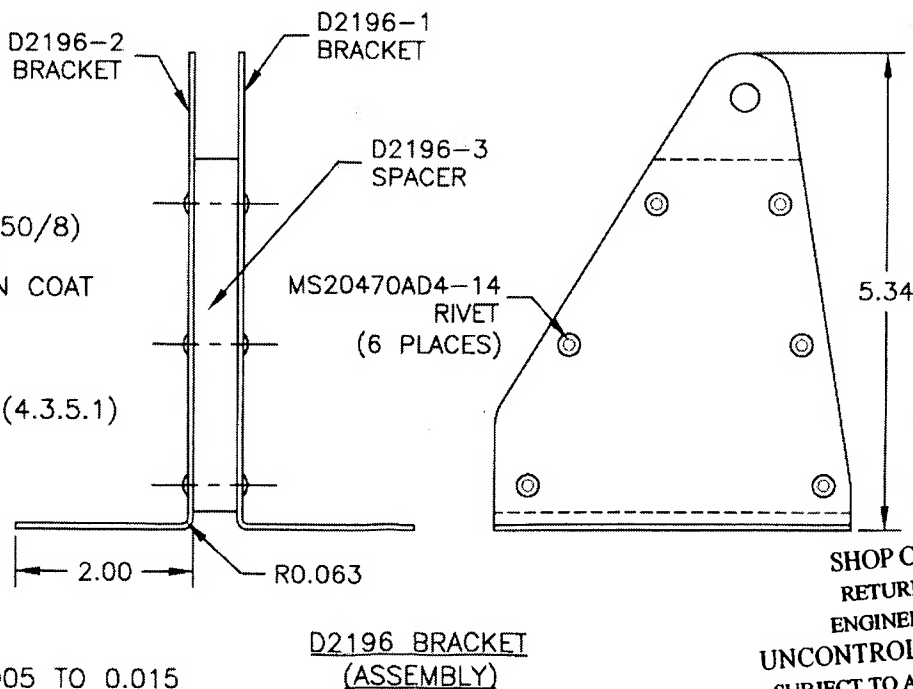
- 2) MATERIAL: 5052H32 (QQ-A-250/8)  
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1

#### D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)  
PER DART QSI 005 4.3

#### GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

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NO. 40160

|  |  |                             |
|--|--|-----------------------------|
| <b>DART AEROSPACE LTD</b>                    |  | <b>Work Order:</b> 40760    |
| <b>Description:</b> BRACKET                  |  | <b>Part Number:</b> D2196-1 |
| <b>Inspection Dwg:</b> D2196-1 <b>Rev:</b> C |  | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .128            | + .005 - .001 | .129             | *      |        |                      |          |
| Ø .203            | + .005 - .001 | .204             | *      |        |                      |          |
| Ø .316            | + .006 - .001 | .317             | *      |        |                      |          |
| .375              | +/- .010      | .375             | *      |        |                      |          |
| .813              | +/- .010      | .813             | *      |        |                      |          |
| 1.750             | +/- .010      | 1.751            | *      |        |                      |          |
| 2.688             | +/- .010      | 2.689            | *      |        |                      |          |
| 3.625             | +/- .010      | 3.626            | *      |        |                      |          |
| 4.008             | +/- .010      | 4.004            | *      |        |                      |          |
| .375              | +/- .010      | .375             | *      |        |                      |          |
| 1.200             | +/- .010      | 1.200            | *      |        |                      |          |
| 2.390             | +/- .010      | 2.385            | *      |        |                      |          |
| 3.960             | +/- .010      | 3.960            | *      |        |                      |          |
| 5.530             | +/- .010      | 5.530            | *      |        |                      |          |
| 6.730             | +/- .010      | 6.732            | *      |        |                      |          |
| 7.230             | +/- .010      | 7.232            | *      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                       |                                  |
|------------------------|-----------------------|----------------------------------|
| <b>Measured by:</b> RB | <b>Audited by:</b> S  | <b>Prototype Approval:</b> 12/14 |
| <b>Date:</b> 8-8-21    | <b>Date:</b> 08/08/21 | <b>Date:</b> 12/14               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

